

shp 27/05 or sooner

Work Order ID 101889

101889

Page 1

May-21-13 9:42:14 AM

Item ID: D3467-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cover Plate RH

Start Date: 5/21/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3467	Rev C

100 FLOW WATER JET 0.00

100

Waterjet Memo 0.00

FLOW CNC Waterjet Cut as per Dwg D3467

304.018

Dwg Rev: C

Prog Rev: C

4 0 JmB-5-21

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC Memo 0.00

Quality Control

4 0 JmB-5-21

101889

May-21-13 9:42:14 AM

N900040100

Setup Start ***NS1***

Stop *NS2*

Start Date: 5/21/13 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 5/24/13 **Req'd Qty:** 4.00 *** / ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

120

0.00

DAS
27
B. S 22

0.00

130

0.00

2-Form as per dwg D3467

0.00

140

0.00

AS
27
28
BS 22

101889

May-21-13 9:42:14 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/21/13 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 5/24/13 **Req'd Qty:** 4.00 *** / ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

Identify as per dwg & Stock Location:_____

0.00

150

Memo

0.00

Packaging

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

Memo

0.00

QC

Quality Control

MLJ 17-05-23

WMA
13-5-27

Picklist Print

May-21-13 9:42:14 AM

Page 1

Work Order ID: 101889

Parent Item: D3467-2

Start Date: 5/21/13

Required Date: 5/24/13

Parent Item Name: Cover Plate RH

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.05.21 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S26GA
304/316 0.018 SHEET

Purchased

No

100

sf

288.7400

0.736

~~3.0989474~~
3.1

Jm 3-5-21

Location

Loc Qty

Loc Code

MAT020

288.74

117798

69.28

122753

97.06

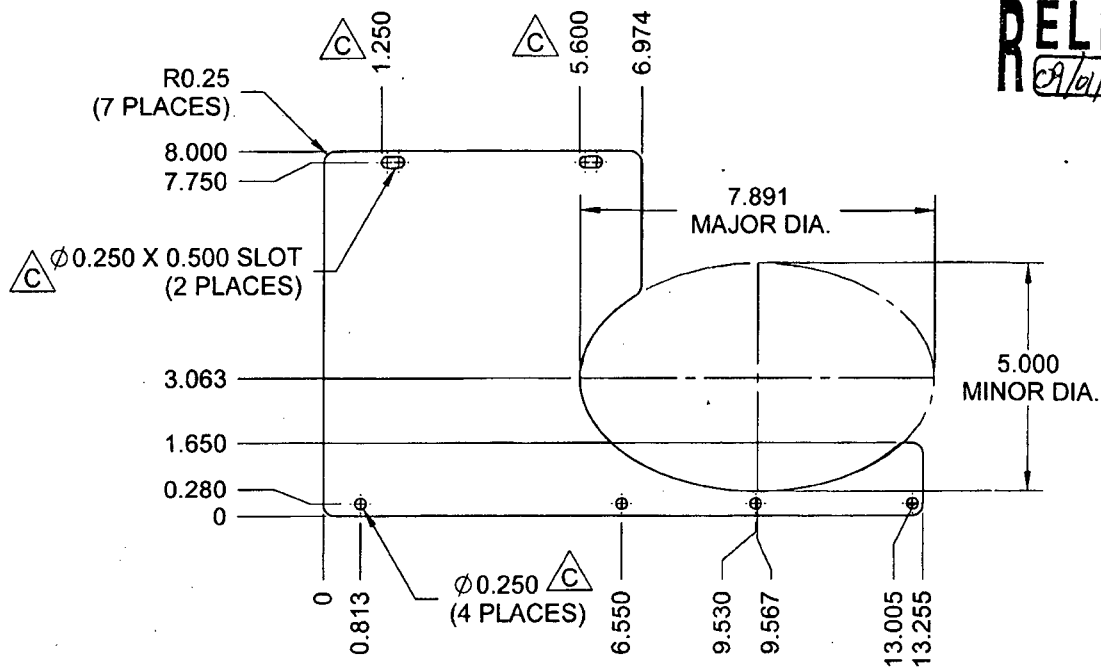
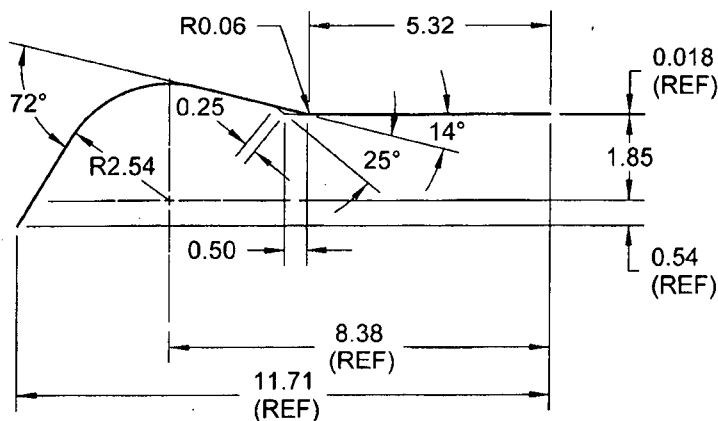
123135

122.4

122753

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3467	REV. C SHEET 6 OF 15
DATE 08.12.19		TITLE SHROUD ASSEMBLY	SCALE 1:4

**D3467-1F COVER PLATE FLAT PATTERN****D3467-1 L/H COVER
PLATE ISOMETRIC VIEW.
D3467-2 R/H COVER
PLATE (OPPOSITE)
SCALE 1:8****NOTES:**

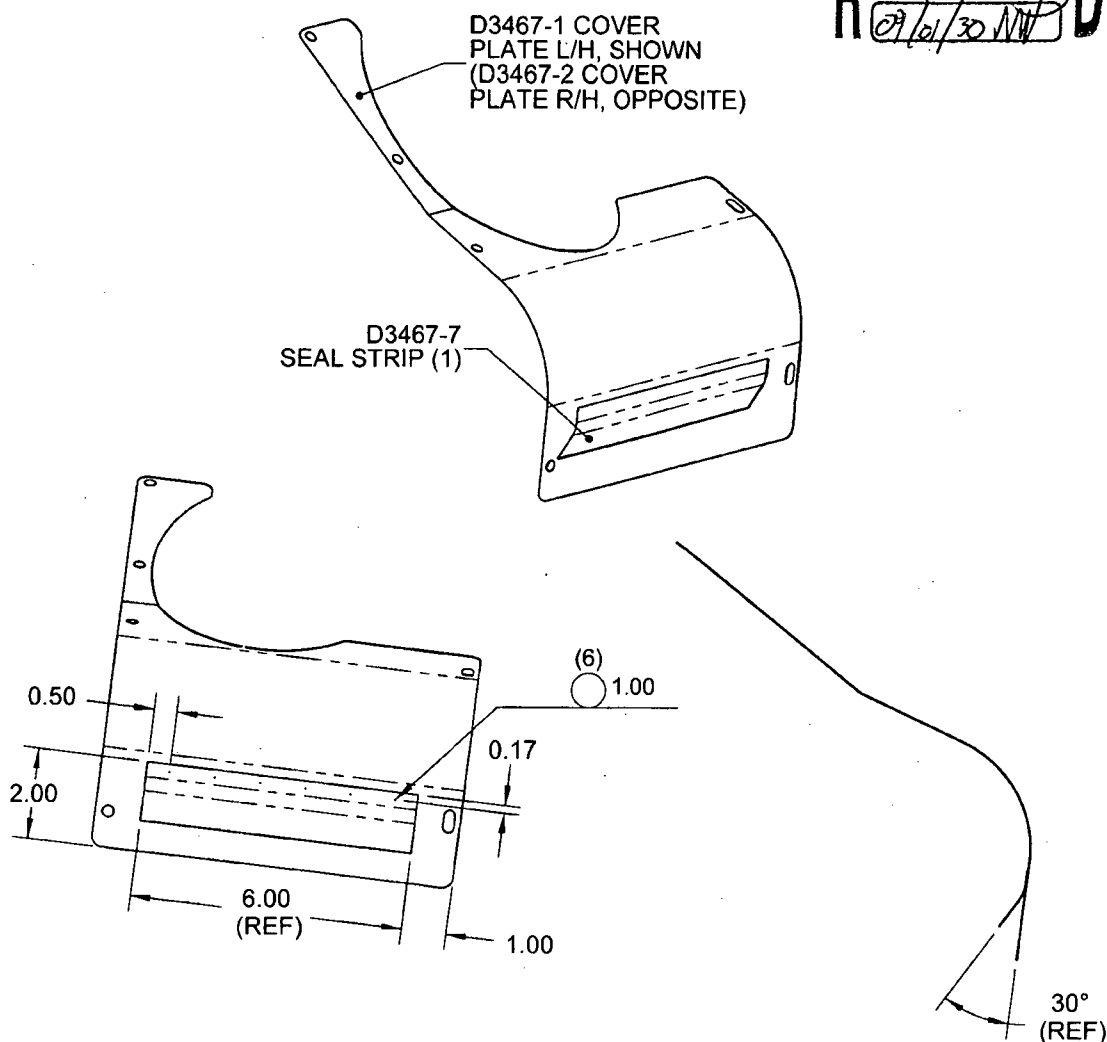
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH \triangle
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3467	REV. C SHEET 4 OF 15
DATE 08.12.19	TITLE SHROUD ASSEMBLY		SCALE 1:4

RELEASED
09/01/30 M

D3467-047 COVER PLATE ASS'Y L/H, SHOWN
D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO
0.010

QTY -047	QTY -048	P/N	DESCRIPTION
X		D3467-047	COVER PLATE ASSEMBLY, L/H
	X	D3467-048	COVER PLATE ASSEMBLY, R/H
1		D3467-1	COVER PLATE, L/H
	1	D3467-2	COVER PLATE, R/H
1	1	D3467-7	SEAL STRIP

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